



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2661-1

Job Sheet 199022



Part No: D2661-1

Job Qty: 4 pcs

Part Name: Saddle, LH, Fwd, Aft, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/9/19

Job Tracking No:

Due Date: 8/16/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP REV:D REDESIGN
PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	4 pcs		8/16/19	1.00	4.49	HAAS - 1		SBL 19/09/10
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	Conventional Mill - 1 - B4B	4 pcs		8/16/19	0.00	2.56	Conventional Mill - 1 - B4B		SBL 19/09/10
							Conventional Mill - 2 - B4B		
120	QC 2	4 pcs		8/16/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



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CANADA
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Container No: S212308



Part: D2661-1

Job No: 199022

Serial No/Batch: S212308

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/10/19

Plex 8/9/19 10:56 AM Dart.lajeunesse.marie

					QC 2 - 57	SBL 19/09/11
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	SBL 19/09/20
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
140	Handfinish - 1-1 Chemical-B4B	4 pcs	8/16/19	0.00 0.11	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	SBL SEP 20 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White GI(A)-	4	8/16/19	0.00 0.16	Powdercoat - 1 - B4B	SBL 19-9-23

M193454

START: 8:50 O.V.T: 300 FINISH: 9:00.

B4B	pcs			Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
160 QC 3	4 pcs	8/16/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
170 Packaging 3-1 - Stock - B4B	4 pcs	8/16/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
180 QC 21 - SA	4 pcs	8/16/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - (HAAS CNC Vertical Machine) Descriptions: 110 - (Manufacture as per dwg) 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - Chemical Conversion Coat per QSI005 4.1 150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 160 - QC3- Inspect Part Finish 170 - Identify as per dwg & Stock Location: 180 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6101-003	Saddle Billet, 7075	4 pcs (1 ea)	100-HAAS 4 Axis	5195546X4	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-003	4	43	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD				Work Order: 195022	
Description: 206 Saddle, Outboard, Left side				Part Number: D2661-1	
Inspection Dwg: D2661 Rev: E DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	
B	0.256	0.263		.257	.257	.257	.257	
C	0.315	0.322		.316	.316	.316	.316	
D	2.495	2.505		2.500	2.500	2.500	2.500	
E	1.674	1.684		1.680	1.680	1.680	1.680	
F	1.357	1.367		1.361	1.361	1.361	1.361	
G	0.100	0.140		.120	.121	.120	.121	
H	0.210	0.230		.220	.225	.225	.125	
I	0.615	0.685		.680	.675	.675	.675	
J	2.470	2.510		2.495	2.495	2.495	2.495	
K	1.313	1.343		1.318	1.324	1.324	1.324	
L	0.178	0.198		.188	.188	.188	.188	
M	0.470	0.530		.500	.500	.500	.500	
N	1.125	1.145		1.135	1.135	1.135	1.135	
O	0.100	0.180		.135	.135	.135	.135	
P	0.100	0.140		.130	.129	.130	.129	
Q	0.240	0.260		.245	.251	.252	.253	
R	0.677	0.697		.684	.686	.686	.686	
S	0.100	0.140		.118	.118	.118	.117	
T	1.565	1.585		1.575	1.575	1.575	1.575	
U	0.540	0.560		.550	.552	.550	.550	
V	0.912	0.932		.920	.919	.919	.922	
W	0.787	0.807		.797	.799	.797	.797	
X	5.990	6.010		6.000	6.000	6.000	6.000	
Y	4.995	5.005		5.000	5.000	5.000	5.000	
Z	0.490	0.510		.503	.500	.500	.500	
AA	0.312	0.319		.313	.313	.313	.313	
AB	0.990	1.010		1.002	1.004	1.004	1.004	
AC	1.245	1.255		1.250	1.250	1.250	1.250	
AD	0.490	0.510		.506	.500	.510	.510	
AE	3.745	3.755		3.750	3.750	3.75	3.750	
AF	0.235	0.240		.238	.240	.239	.238	
AG	0.510	0.515		.511	.511	.511	.511	
AH	0.100	0.120		.115	.115	.115	.115	

DAS Accept/Reject

Measured by: 57	Date: 19/09/11
Audited by: 9-89 <i>cmf</i>	Date: 19/09/20
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	<i>MA</i>



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

DISPOSITION		DEPARTMENT/PROCESS					
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS042)			
Description Work Order Deviation		Disposition					
						Completed By	
						Lead hand / Supervisor	
						QC / QA Coordinator	
Root Cause		FAULT CATEGORY					
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐		
Other/Details:							